

Attorney Docket: K-2081  
S.N.: 10/766,396

**Amendments to the Specification**

Please replace Paragraph [0019] with the following:

[0019] As mentioned above, the tool length, L, of the conventional toolholder assembly 100 shown in Figure 2 is approximately 5.9 inches (150mm). In many cases, this distance is necessary to allow the spindle housing 108 to clear the work holding device (i.e., the chuck 122 and chuck jaws 124). By inclining or tilting the toolholder spindle 106 at 45.0 degrees, for example, with respect to the axis, P, (and also the longitudinal axis, LW, of the workpiece 120), the tool length, L, can be shortened and still allow clearance for the spindle housing 108 with the work holding device. For example, the tool length, L, of the toolholder 10 of the invention is in a range of approximately 3.15 inches (80 mm) to approximately 4.72 inches (120 mm), and preferably in a range of approximately 3.54 inches (90 mm) to approximately 4.33 inches (110 mm), and most preferably approximately 3.94 inches (100 mm), as compared to approximately 5.91 inches (150 mm) in the conventional toolholder 100. These dimensions refer to a commonly used tooling system size with an outside diameter of 2.480 inches (63 mm). Smaller or larger tooling system sizes would require smaller or larger dimensions, respectively. Because the clamping mechanism of the spindle that holds the toolholder assembly 10 has a substantially constant clamping force, a shorter tool length, L, will yield less deflection under load and provide better cutting performance.